

Docket No.: 132446  
Serial No.: 10/605,909

**Amendments to the Claims:**

This listing of Claims will replace all prior versions and listings of claims in the application.

**Listing of the Claims:**

Claims 1. - 13. (Cancelled)

14. (Amended) A method for machining to remove metal from a workpiece, comprising the steps of:

- 1) providing a holder for a workpiece,
- 2) providing a metalworking tool having a machining interface configured to engage the workpiece along ~~a~~ the machining interface to remove metal from the workpiece,
- 3) cooling the metalworking interface by emitting a stream of a cooling liquid through a nozzle body having a flow passage with an inlet and an outlet, and a bore having an access opening in fluid communication with the flow passage and a line of sight with the flow passage outlet, wherein the access opening is sealed by a removable plug,

wherein prior to the machining, the plug is removed from the bore and a visible laser is inserted into the bore for emitting a laser beam that cooperates with the nozzle body for visually positioning the nozzle relative to the metalworking tool, whereby the emitted stream of cooling liquid is directed at the machining interface.

15. (Previously added) The method according to Claim 14 wherein the provided metalworking tool has an atypical interface profile, and the emitted stream of cooling liquid has an atypical cross-sectional profile substantially the same as the atypical interface profile, and wherein the atypical profile is a shape other than a linear, rectilinear, circular, oval, and curvilinear profile.

16. (Previously added) The method according to Claim 14 wherein the visually positioning of the nozzle comprises aligning the visible laser beam along a line passing through a stream reference point along the flow passage outlet and a machining reference point on the machining interface.

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17. (New) The method according to Claim 14 wherein the flow passage that leads to the outlet is configured with parallel sidewalls and a constant cross-sectional profile, for emitting a stream of a cooling liquid having a profile with the same width and height.

18. (New) A method for aligning a cooling nozzle for supplying coolant to a machining interface of a metalworking tool during the machining of a workpiece, comprising the steps of:

- 1) providing a holder for a workpiece and a workpiece,
- 2) providing a metalworking tool having a machining interface configured to engage the workpiece along the machining interface to remove metal from the workpiece,
- 3) providing a coolant nozzle comprising a nozzle body having a flow passage with an inlet and an outlet, and a laser bore in fluid communication with the flow passage and a line of sight with the flow passage outlet,
- 4) inserting a visible laser into the bore in a stationary position for emitting a laser beam that cooperates with the outlet on the nozzle body for visually positioning the nozzle relative to the metalworking tool,
- 5) manually positioning the nozzle so that the visible laser beam passes to a machining reference point on the machining interface of the metalworking tool,
- 6) securing the nozzle in position, and
- 7) removing the visible laser and inserting and securing a removable plug to seal the laser bore,

whereby the coolant nozzle is properly targeted to emit the coolant stream at the machining interface.

19. (New) The method according to Claim 18 wherein the emitted visible laser beam passes through a stream reference point on the periphery of the outlet of the nozzle.